

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014741**Date Inspected:** 11-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Yang Bai Qiang, Gao Zhi Chun			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG/Tower		

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 10, North Tower Lift 3, Grating Bracket Support (GREEN TAG NO. 12738)

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% and random Visual Testing (VT) of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

GGSA-58PLAN-85M-2-1~5-N

GGSA-58PLAN-85M-3-1~5-N

GGSA-58PLAN-85M-4-1~5-N

OBG TRIAL ASSEMBLY YARD (OBG PP69 & PP71)

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

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BK001-035-001, 002, 006, 007

BK001-036-001, 002, 006, 007

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 9

U-rib Internal Cover Plate

FCAW welding of weld joint 201 located on DP3093-001.

Welder is identified as 201788. ZPMC CWI is identified as Mr. Yang Bai Qiang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW welding of weld joint 38 located on DP3093-001.

Welder is identified as 057148. ZPMC QC is identified as Mr. Yang Bai Qiang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

Bay 10

Tower Grillage plate

SMAW welding of weld joint 1A located on SSD1-SPSA5-6.

Welder is identified as 050266. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

SMAW welding of weld joint 2A located on NSD1-SPSA5-16.

Welder is identified as 057258. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-3211-Tc-U5b-1.

Tower Facade Plate

FCAW welding of weld joint 3 located on SD1-SPSA4-49A/B.

Welder is identified as 054609. ZPMC QC is identified as Mr. Yu Zhi Lai.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Tower Skirt Plate

FCAW welding of weld joint 3 located on NSD1-A802C/D.

Welder is identified as 053870. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2133.

FCAW welding of weld joint 61 located on NSD1-A802D/D.

Welder is identified as 052075. ZPMC QC is identified as Mr. Jiang Xiao Bo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F-2.

BAY 11

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Tower Strut Repair

SMAW welding of weld joint 8A/B(Repair) located on WD1-STSA4-5-119M-1.

Welder is identified as 040656. ZPMC CWI is identified as Yu Dong Ping.

The welding variables recorded by QC appeared to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
